

AMENDMENT TO THE CLAIMS

1. (Currently Amended) A method for manufacturing a product having a constant diameter or various diameters from a workpiece, in which the workpiece is clamped down in a clamping device, the workpiece and a first set of forming rollers are rotated about an axis of rotation relative to each other, wherein the rollers of the first set take up a first same axial position with respect to the work piece, wherein the workpiece is deformed by means of said forming rollers by placing the forming rollers into contact with the workpiece and moving the workpiece and/or the forming rollers in a direction along said axis of rotation, wherein at least a second set of forming rollers positioned at a second same axial position with respect to the work piece is placed into contact with the workpiece at a position behind the first set of forming rollers, the workpiece also being deformed by means of said second set of forming rollers and wherein two or more forming rollers, each being of a different set and taking up a different axial position with respect to the work piece, are mounted on a common holder and said holder is ~~rotated~~ tiltable about a tilting axis toward and away to said axis of rotation wherein said ~~about an tilting axis, which~~ crosses said axis of rotation ~~and/or radially adjusted~~ during the working of the workpiece into a selected shape.

2. (Cancelled)

3. (Cancelled)

4. (Cancelled)

5. (Cancelled)

6. (Previously presented) The method according to claim 1, wherein at least a third set of forming rollers are placed into contact with the workpiece at a position behind the second set of

forming rollers.

7. (Previously Presented) The method according to claim 1, wherein the first and second set of forming rollers each comprise two or more forming rollers, between which the workpiece is retained while being worked.
8. (Previously Presented) The method according to claim 1, wherein the workpiece is formed into a finished or semifinished product in only one working cycle.
9. (Previously Presented) The method according to claim 1, wherein a tensile force is exerted on the workpiece.
10. (Previously Presented) The method according to claim 9, wherein said tensile force is varied during said working.
11. (Previously Presented) The method according to claim 1, wherein at least one of the first or second set of forming rollers is adjusted in a radial direction during said working.
12. (Previously Presented) The method according to claim 1, wherein the workpiece has an open end, which end is closed by means of the forming rollers.
13. (Previously presented) The method according to claim 1, wherein the workpiece is a plate-shaped body, and wherein the central axis of the common holder is pivoted relative to the axis of rotation.
14. (Previously Presented) The method according to claim 13, wherein the first and second set of forming rollers are moved relative to each other during said working.

15. (Previously Presented) The method according to claim 13, wherein the edge of the workpiece is supported at least during part of the operation.

16. (Previously presented) A forming machine suitable for manufacturing products which forming machine comprises at least a clamping device for clamping down a workpiece, a first set of forming rollers, which can be placed into contact with the workpiece while being worked, means for rotating the workpiece and the first set of forming rollers about an axis of rotation relative to each other, and means for moving the workpiece and/or the first set of forming rollers in a direction along said axis of rotation, and at least a second set of forming rollers disposed behind said first set of forming rollers, which can be placed into contact with the workpiece and wherein two or more forming rollers associated with different sets of forming rollers are mounted on a common holder such that perimeters of adjacent forming rollers at least partially overlap and wherein the first set of forming rollers are spaced apart from the second set of rollers such that the first and second sets of rollers do not contact each other and said holder is pivottally mounted in or on the forming machine in such manner as to be capable tilting toward or away from said axis of rotation such that a tilting axis of the holder of rotation about an axis which crosses said axis of rotation ~~and/or of radial translation~~ during the forming process of the workpiece.

17. (Cancelled)

18. (Cancelled)

19. (Previously Presented) The forming machine according to claim 16, comprising at least a third set of forming rollers disposed behind said second set of forming rollers.

20. (Previously Presented) The forming machine according to claim 16, wherein the first and second sets of forming rollers each comprise two or more forming rollers, between

which the workpiece can be retained.

21. (Previously Presented) The forming machine according to claim 16, wherein the first and second sets of forming rollers can be moved relative to each other during the working.

22. (Previously Presented) The forming machine according to claim 16, comprising a mandrel or bush to be placed in or around, respectively, an unworked part of the workpiece, and by means of which a tensile force can be exerted on the workpiece.

23. (Cancelled)

24. Cancelled)

25. (Cancelled)

26. (Cancelled)

27. (Cancelled)

28. (Previously Presented) The method according to claim 1, wherein the workpiece comprises a metal cylinder or plate.

29. (Currently Amended) A forming machine suitable for manufacturing products which forming machine comprises at least a clamping device for clamping down a workpiece, a plurality of forming rollers mounted on a first common holder, which can be placed into contact with the workpiece while being worked, means for rotating the workpiece and the plurality of forming rollers about an axis of rotation relative to each other, and means for moving the workpiece and/or the plurality of forming rollers in a direction along said axis of rotation,

wherein the first common holder moves radially with respect to an axis of rotation of the workpiece and also moves pivotally with respect to the axis of rotation of the workpiece and at least one or more forming rollers mounted on a second holder and spaced from the first common holder wherein the second holder moves radially with respect to the axis of rotation of the workpiece, wherein at least one of the plurality of forming rollers mounted on the first common holder and the at least one forming roller mounted on the second holder engages the workpiece and wherein the first and second holders are mounted in or on the forming machine in such manner such that the first common holder is capable of rotation about an axis which crosses said axis of rotation ~~and/or of radial translation~~ during the formation of the workpiece.

30. (Previously presented) The forming machine of claim 29 and wherein each of the forming rollers are radially positionable independent of the other rollers.

31. (Currently amended) A method for manufacturing a product having a constant diameter or various diameters from a workpiece, in which the workpiece is clamped down in a clamping device, the workpiece and a first set of forming rollers are rotated about an axis of rotation relative to each other, wherein the rollers of the first set take up a first same axial position with respect to the work piece, wherein the workpiece is deformed by means of said forming rollers by placing the forming rollers into contact with the workpiece and moving the workpiece and/or the forming rollers in a direction along said axis of rotation, wherein at least a second set of forming rollers positioned at a second axial position with respect to the work piece is placed into contact with the workpiece at a position behind the first set of forming rollers, the workpiece also being deformed by means of said second set of forming rollers and wherein two or more forming rollers, each being of a different set and taking up a different axial position with respect to the work piece, are mounted on a common holder and said holder is rotated about an axis which crosses said axis of rotation ~~and/or radially adjusted~~ during operation such that an outer surface of the workpiece is contacted by the first and second set of rollers.

- 32. (New) The method of claim 1 wherein the common holder is radially adjusted during the working of the workpiece.
- 33. (New) The machine of claim 16 wherein the common holder is radially adjusted during the working of the workpiece.
- 34. (New) The machine of claim 29 wherein the common holder is radially adjusted during the working of the workpiece.
- 35. (New) The method of claim 31 wherein the common holder is radially adjusted during the working of the workpiece.